

Date: Tuesday, 19/08/2008 4:04:01 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 41430	
Estimate Number : 10600	
P.O. Number :	Part Number : D2519
This Issue : 19/08/2008 S.O. No. :	Drawing Number : D2519 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 34306	Material :
Written By :	Due Date : 30/09/2008 Qty: 50 Um: Each
Checked & Approved By : <u>NO 08-8-19</u>	
Comment : Est: B 00.03.16 Re-format, laser cutting EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 7002 C 26/08/121
Laser cut as per Dwg D2519
Material release note required

(50)

2.0	D2519F	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
Clamp

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

AS 08/09/16 (x50)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK
(8.561" center to center)

08/09/16 (x50) corrected

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Deburr any rough edges after tumbling
2-Bend as per Dwg D2519

08/10/10 (51)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:01 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 41430

Part Number: D2519

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



(P5)

Comment: INSPECT WORK TO CURRENT STEP

508/10/10 (51) counter

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

8-10-9

(51)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 476

8-10-10 (51)

9.0

QC21

FINAL INSPECTION W/O RELEASE



08/10/14

Comment: FINAL INSPECTION W/O RELEASE

Job Completion



MF 08-10-10

Dart Aerospace Ltd

W/O: 41430		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
8/6/18	60 70	change operation of step 6. and step 7. Tanker should be enfont of respect a/c. PERMANENT CHANGE ESTIMATE: 10600	MA	08/10/14			8/9/18

Part No: D2519 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

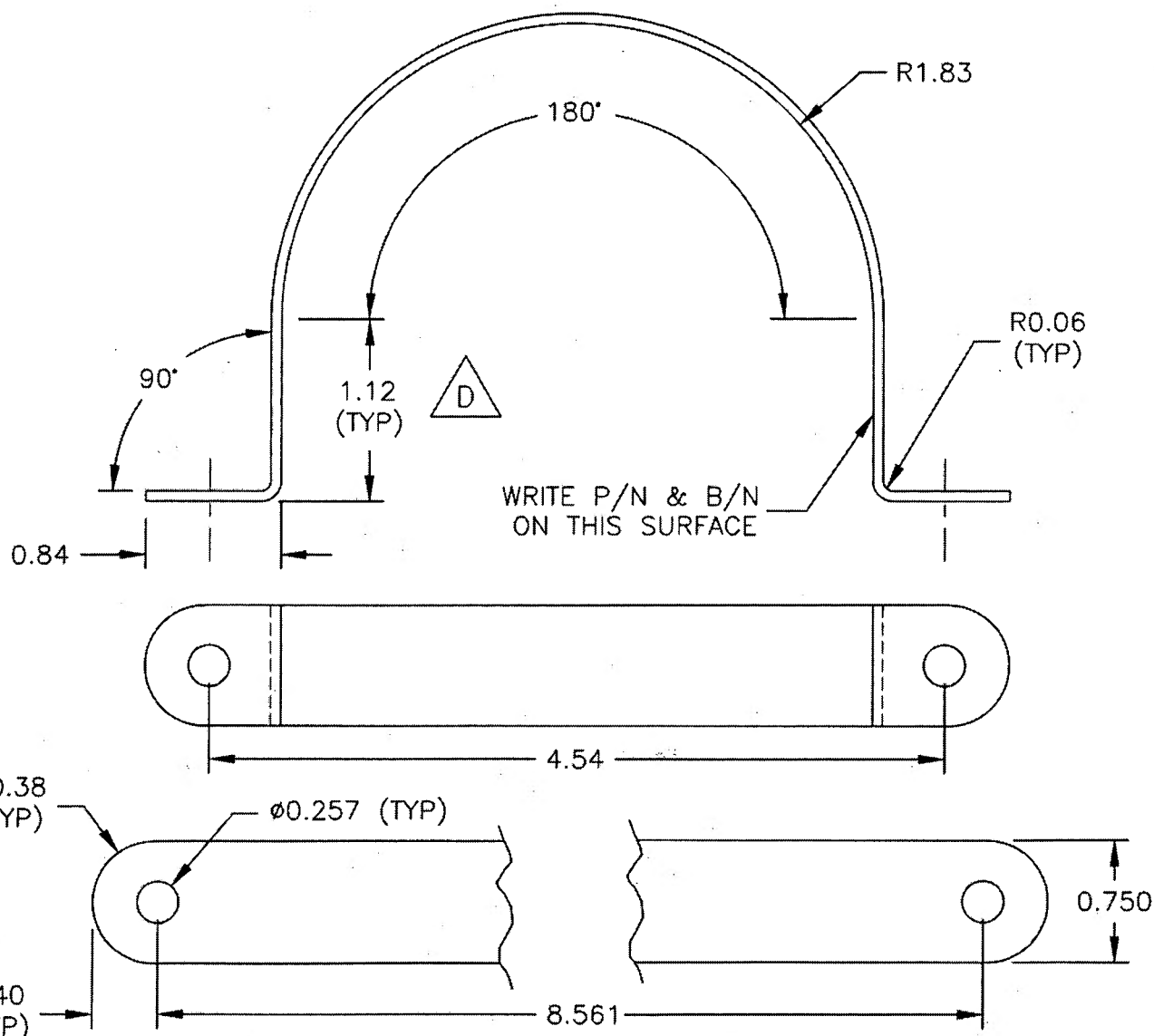
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2519	REV. D SHEET 1 OF 1
DATE 04.11.08		TITLE CLAMP	SCALE 1:1
A	95.11.28	NEW ISSUE	
B	97.03.24	ADD MATERIAL SPECIFICATION	
C	00.02.29	REDRAWN; ADDED FLAT PATTERN	
D	04.11.08	1.12 WAS 0.93	

RELEASED
04.11.26 [Signature]



D2519 FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK, (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSION ARE IN INCHES
- 4) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER ON SURFACE SHOWN



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

PRODUIT À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7



EXPÉDIÉ À / SHIPPED TO

BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2008/09/11	0402538

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP? VIA
DART GFI-0299		J0189517	PO00007002	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.		DESCRIPTION	
50	D2519F ✓ 8/12/2008 J 18 08/09/16		CLAMP	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RECEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

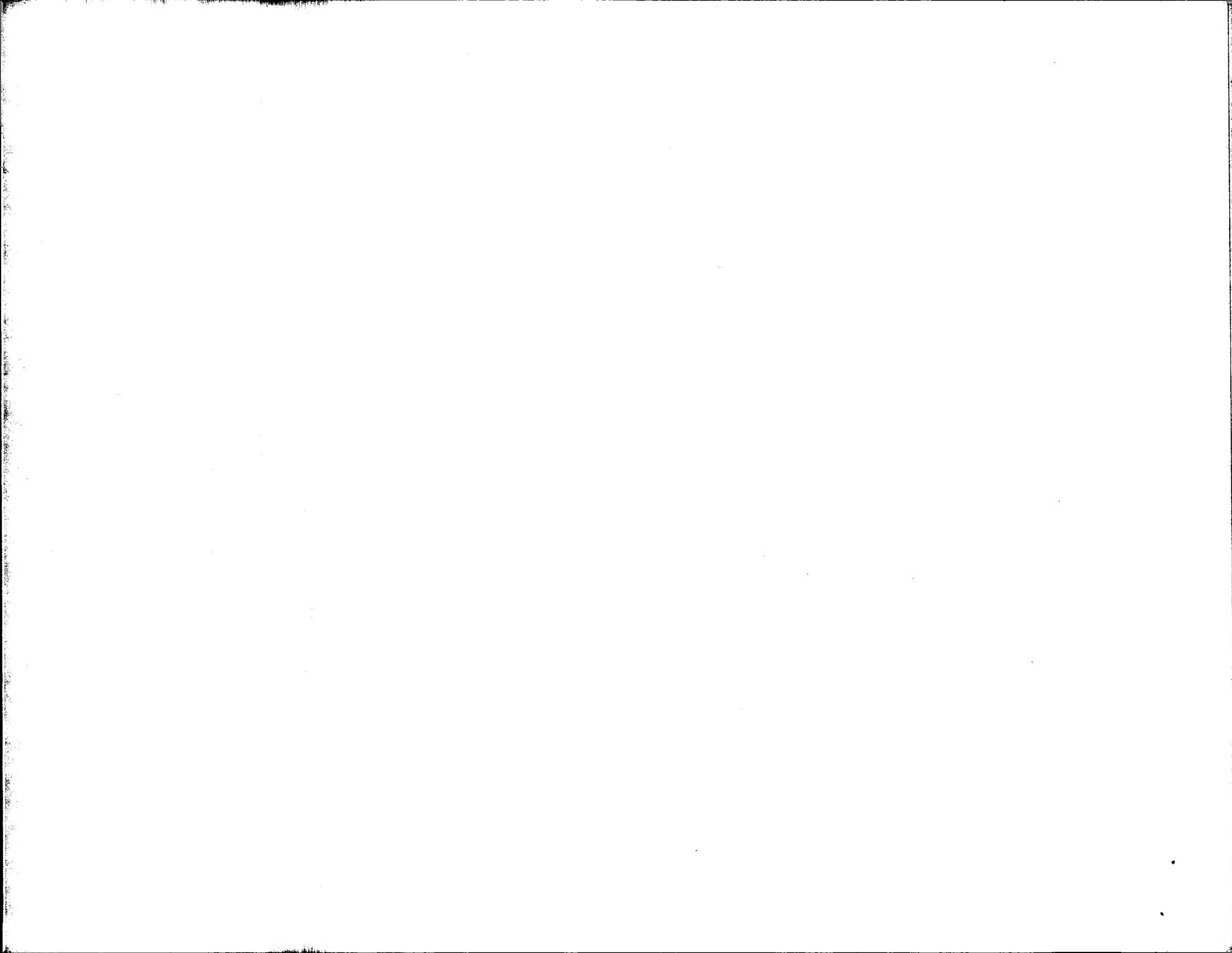
CERTIFICATE NO. 3		OUR JOB NO J0189517		SHIPPING MEMO 0402538		
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
50 PCS	PO00007002	D2519F	D	CLAMP	D	
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
S.S.T 304		SAMUEL / AK STEEL		7380365 ATT'D		
	PROCESS	PROCESSOR <i>08/09/18</i>		RELEASE NOTE #		
1						
2						
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **11 SEPTEMBER 2008**

G.F.I. Q.C. REP. *Callan Smith*







Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ --LETTER OF COMPLIANCE

Date: 3 SEPTEMBRE 2008

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: CC03584
Customer's order #:

de commande SSMQ: 883529
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	15	.060" X 48" X 96"	304 2B		7380365

Bien à vous,
Yours truly,



Muriel Giffiths

Commis à l'administration.
Administration Clerk.



AK Steel Corporation
Metallurgical Test Report
Rockport Works
Rockport, IN 47635

Page 1

Load No. 8970283
 SRN No. 8970283

CUSTOMER

SAMUEL & FILS & CIE LTEE (S)
 PUR DEPT
 2225 FRANCIS HUGHES DRIVE
 LAVAL, CN H7S1N 5

SHIP TO

SAMUEL & FILES (QUEBEC) LTEE
 2225 FRANCIS HUGHES
 LAVAL, CN H7S1N-5

MILL ORDER NO.
 252502-1172

PROCESSOR ORDER NO.
 C10360-3

BUYERS ORDER NO.
 C10360-3

PART NO.

ENGLISH UNITS --PRODUCT-- METRIC UNITS
 .0590 NOM 48.0000 X COIL

See local file

COIL ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT	OUTSIDE PROCESSOR ID
127733-01BAAB	1	7380365	0127733-01BAA	19,960 LBS. 9,054 KG.	466346802
TOTAL COILS	TOTAL PIECES			TOTAL NET WEIGHT	
1	1			19,960 LBS. 9,054 KG.	

L-Ladle Analysis of Heat

P-Product Analysis of Parent Coil

CHEMICAL ANALYSIS

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7380365	.023	1.240	.025	.0026	.385	18.11	8.09	.29	.0330	.44						

SHIPPING DATE: 06/14/2008

REMARKS:

NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE
 MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL.
 MATERIAL FREE OF RADIOACTIVE ISOTOPES

PRODUCT DESCRIPTION

CR SHT TYPE 304/304L STAINLESS #2B FINISH SLIT EDGE TEST REPORTS * ASTM A 240 -07 * ASTM A 480 -06 EX PARA 25.1.1.3 COIL WILL B
 E TAGGED ON OUTSIDE ONLY * ASME SA-240 SECTION II PART A (2004 ED, 2005 ADDENDA) * ASME SA-480 SECTION II PART A (2004 ED, 2005
 ADDENDA) * ASTM A 262 -02A2 PRACTICE E * ASTM A 666 -03 EX 7.1 TEST SPECIMENS WILL BE SELECTED IN THE TRANSVERSE TEST DIRECTION
 IN ALL CASES.

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	% ELONG	TENSILE STRENGTH (KSI)	Y.S. .2% OFFSET (KSI)	ROCKWELL HARDNESS Tail	ROCKWELL HARDNESS Front			
0127733-01BAA	T	T	A.S.T.M	58.8	98.6	45.1	B 83	B 84			
PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	ASTM A 262 PRACTICE E	BEND 180 IT						
0127733-01BAA	T		A.S.T.M	PASS	PASS						

THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT
 AS CONTAINED IN THE RECORDS OF THE CORPORATION.

ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M. STANDARDS UNLESS OTHERWISE NOTED

AK Steel Corporation

MW/CL/0004 5/04

SIGNED:

RYAN MARTIN QUALITY MANAGER

DATE: 06/15/2008 TIME: 09:57 AM

"THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK
 Steel Corporation. TO AVOID THE POSSIBILITY OF ITS MISUSE ON DELIVERY OF THE REPORT TO A
 THIRD PARTY IT MUST BE RECERTIFIED BY AND UNDER THE NAME OF SUCH CONSIGNEE"